

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012687**Date Inspected:** 16-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

MAGNETIC PARTICLE INSPECTION

OBG SEGMENT 6 WEST & 6EAST

This Q.A Inspector performed Magnetic particle Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the OBG segment 6West and 6 East Designation are as follows.

DP516-001-023, 052, 032, 044, 048; DP513-001-026, 032, 044, 048; DP515-001-026, 032.

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7AW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 045196, 066361 performing Shielded Metal Arc Welding process for weld OBW7-003 located on PCMK deck panel splice weld between OBG segment

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7AW and 7BW. ZPMC QC Mr. Zhong Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066326 performing Shielded Metal Arc Welding process for weld OBW7-002 located on PCMK deck panel splice weld between OBG segment 7AW and 7BW. ZPMC QC Mr. Zhong Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2214-B-U2-FCM-1.

OBG SEGMENT 7CW-7BW

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 068917 performing Shielded Metal Arc Welding process for weld OBW7-006 located on PCMK edge panel splice weld between OBG segment 7CW and 7BW (counter weight side). ZPMC QC Mr. Zhong Yang Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P2213-B-U2-FCM-1.

OBG SEGMENT 7AE-7BE

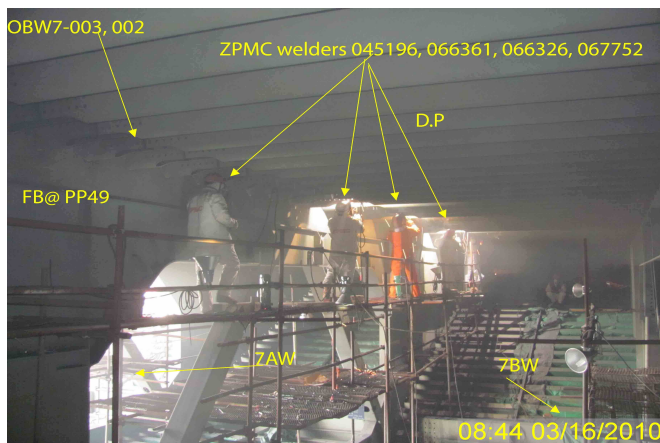
This Quality Assurance (QA) Inspector observed ZPMC Inspector performing ultrasonic inspection for the side panel splice weld between OBG segment 7AE and 7BE (bike path side).

OBG SEGMENT 7CE

This Quality Assurance (QA) Inspector observed ZPMC qualified welders 058087 performing Shielded Metal Arc Welding process for weld CA039-004 located on PCMK weld between edge panel and deck panel (bike path side).

ZPMC QC Mr. Tang Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-2G (2F) –FCM-Repair-1. Critical weld repair report identified as B-CWR1227.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant
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Quality Assurance Inspector

Reviewed By:	Dawson,Paul
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QA Reviewer
